

Work Order ID 66302

Wednesday, February 09, 2011 1:14:11 PM



Page 1

Item ID: D3391-021

Accept



Setup Start



Revision ID:

Item Name: Fwd Tube Assembly

Stop



Start Date: 2/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3391	Rev H
-------	-------

100	Skidtubes	0.00
-----	-----------	------

	Skidtubes
--	-----------

Skidtubes	Memo	0.00
-----------	------	------

Skidtubes	Cut extrusion to 46.52 +0.010 -0.020
-----------	--------------------------------------

110	BENDING MACHINE - SKIDTUBES	0.00
-----	-----------------------------	------

	Memo	0.00
--	------	------

CNC Bend 1	Bend as per Dwg D3391 Using Bend Prog 3391021
------------	---

120	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

	Memo	0.00
--	------	------

QC

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66302



Page 2

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA590 Rev. A & Dwg D3391 Rev. H
Identify as D3391-1
2-Deburr

29 11-5-5

140



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

29 11-5-5

150



CONVENTIONAL MILLING MACHINE

0.00

Mill Conv

Memo

0.00

Conventional Milling Machine

Drill X1 Aft cap as per Dwg D3391 .1875" dia

Jan 11-05-07 1 P

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



QC

Quality Control

QC8- Inspect parts - second check

0.00

0.00

Jan 11/05/07 1 Ø

JL 11/05/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Cust Item ID:

Required Date: 2/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

180

Operation
Description

Skidtubes

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Skidtubes

Memo

0.00

1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875"
holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5- open float bag holes 0.328" and counter sink as per dwg D3391

6-Deburr & Scribe Batch number Inside aft end.

7-Transfer drill D3391-024 with D3391-023

190



QC5- Inspect part completeness to step on W/O

0.00

0.00

5/10/17
HC

QC

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 2/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200



Chemical Conversion Coat per QSI005 4.1

0.00

1 / 6 11-5-17

HandFinish

Memo

0.00

Hand Finishing

210



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

DP

11-5-17

220



Skidtubes

0.00

Skidtubes

Memo

0.00

1-instal spacers as per dwg D3391
A/R Magnabond 6398 batch: M110677
exp. date: 11-08-30
cure time 12hrs. as per QSI015
2- grind crossbolt flush
3-back drill crossbolt if necessary

DP

11-5-17

DP

11-5-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 66302

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Item ID: D3391-021**Accept****Setup Start****Revision ID:****Stop****Item Name:** Fwd Tube Assembly**Start Date:** 2/9/2011 **Start Qty:** 1.00**Cust Item ID:****Required Date:** 2/11/2011 **Req'd Qty:** 1.00**Customer:****Reference:****Approvals:** **Process Plan:****Date:****Tooling:****Date:****Run Start****QC:****Date:****SPC (Y/N):****Date:****Stop****Sequence ID/
Work Center ID**

230



QC

Quality Control

**Operation
Description**

QC5- Inspect part completeness to step on W/O

**Set Up/
Run Hours**

0.00

Tool ID**Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

8/11/05/19

235



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

240



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M 116964

0.00

MemoSTART TIME: 2:05
OVEN TEMPERATURE: 320
FINISH TIME: 2:35

L 8/11/05/19

1 BL 11-5-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID 66302

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**Item ID:** D3391-021**Accept****Setup****Start****Revision ID:****Stop****Item Name:** Fwd Tube Assembly**Start Date:** 2/9/2011 **Start Qty:** 1.00**Cust Item ID:****Required Date:** 2/11/2011 **Req'd Qty:** 1.00**Customer:****Reference:****Approvals:** **Process Plan:****Date:****Tooling:****Date:****Run****Start****QC:****Date:****SPC (Y/N):****Date:****Stop****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

250



QC3- Inspect Part Finish

0.00

1

0

M

u105120

QC

Memo

0.00

Quality Control

255



Skidtubes

0.00

Skidtubes

Memo

0.00

Skidtubes

**** install D3591-1 spacer as per DSI9364 and wearplate and gasket as per DWG ****

1

0

M

u108120

257



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8 u108124

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 2/9/2011 Start Qty: 1.00



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Required Date: 2/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

260

Identify as per dwg & Stock Location: w/oSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00 D412-742-043/364980

0.00

1/10/2011

Packaging

Memo

Packaging

280



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

11/15/2011

MF
11-05-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, February 09, 2011 1:14:08 PM

Work Order ID: 66302



Parent Item: D3391-021



Parent Item Name: Fwd Tube Assembly

Start Date: 2/9/2011

Required Date: 2/11/2011

Comments:

IPP A 05.09.13 New issue: KJ/JLM
 IPP B 06.02.10 Dwg rev.D ecn 773 EC
 IPP C 06.05.02 Added inspections EC
 IPP D 07.03.13 rev F dwg EC
 IPP E 07.11.07 revG dwg ecn1053P EC verified by: DD
 IPP Rev:F ECN 1056 07-11-12 DD verified by: EC
 IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC
 IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC
 IPP Rev J 09.02.02 added hardware EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6013-047



Manufactured

No

100

Each

31.0000



Skidtube Material

Location

LG

23935
26547

Loc Qty

31

3

28

Each

Loc Code

1

4



11-5-5

D3670-4-200



Manufactured

No

220

Each

71.0000



SPACER

Location

LG

B68107
57349
63317
66041

Loc Qty

71

19

12

40

Each

Loc Code

4

4



11-5-17

D3401-041



Manufactured

No

255

Each

11.0000



Tow Cap Assembly

Location

EP

46029
50316

Loc Qty

11

10

1

Loc Code

X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Wednesday, February 09, 2011 1:14:08 PM

Work Order ID: 66302



Parent Item: D3391-021



Parent Item Name: Fwd Tube Assembly

Start Date: 2/9/2011

Required Date: 2/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-13 Manufactured No 255 Each 11.0000 1 1 xl u105(20



Wearshoe

Location	Loc Qty	Loc Code	
FP17	11	346805	x1
59660	1		
62229	10		

D3566-13 Manufactured No 255 Each 21.0000 1 1 xl u105(20



Gasket

Location	Loc Qty	Loc Code	
FP012	1	346560	
61996	1		x1
FP014	20		
64070	20		

AN960C10L NAS1149C0332 Purchased No 255 Each 25.0000 10 10



washer

Location	Loc Qty	Loc Code	
ST245	25		x10
107534	25		

AN3C4A Purchased No 255 Each 1.680.000 10 10



BOLT

Location	Loc Qty	Loc Code	
ST350	1680	M117313	x10
115300	25		
116075	571		
116590	84		
116704	1000		

PTO =>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/05/20	255	install (v1) D3401-041/B 46029 TOWCAP	M	11/05/20	X1		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Parent Item: D3391-021



Parent Item Name: Fwd Tube Assembly

Start Date: 2/9/2011

Required Date: 2/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

255

Each

1,153.000

4

4

SL u los(7)



Phenolic Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST077	1153	
42329	10	
<u>52505</u>	143	<u>x4</u>
64177	1000	

AELS-1032-130

Purchased No

255

Each

0.0000
*FALL 7331 (*2)*

2

2

SL u los(20)

INSERT

AELS-1032-225

Purchased No

255

Each

0.0000
M110768

10

10

SL u los(20)

INSERT

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART AEROSPACE LTD	Work Order:	60302
Description: Float Skidtube (412)	Part Number:	D3391-1
Inspection Dwg: D3391	Rev: H	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: DQ / 6/2011

Audited by: SL

Prototype Approval: N/A

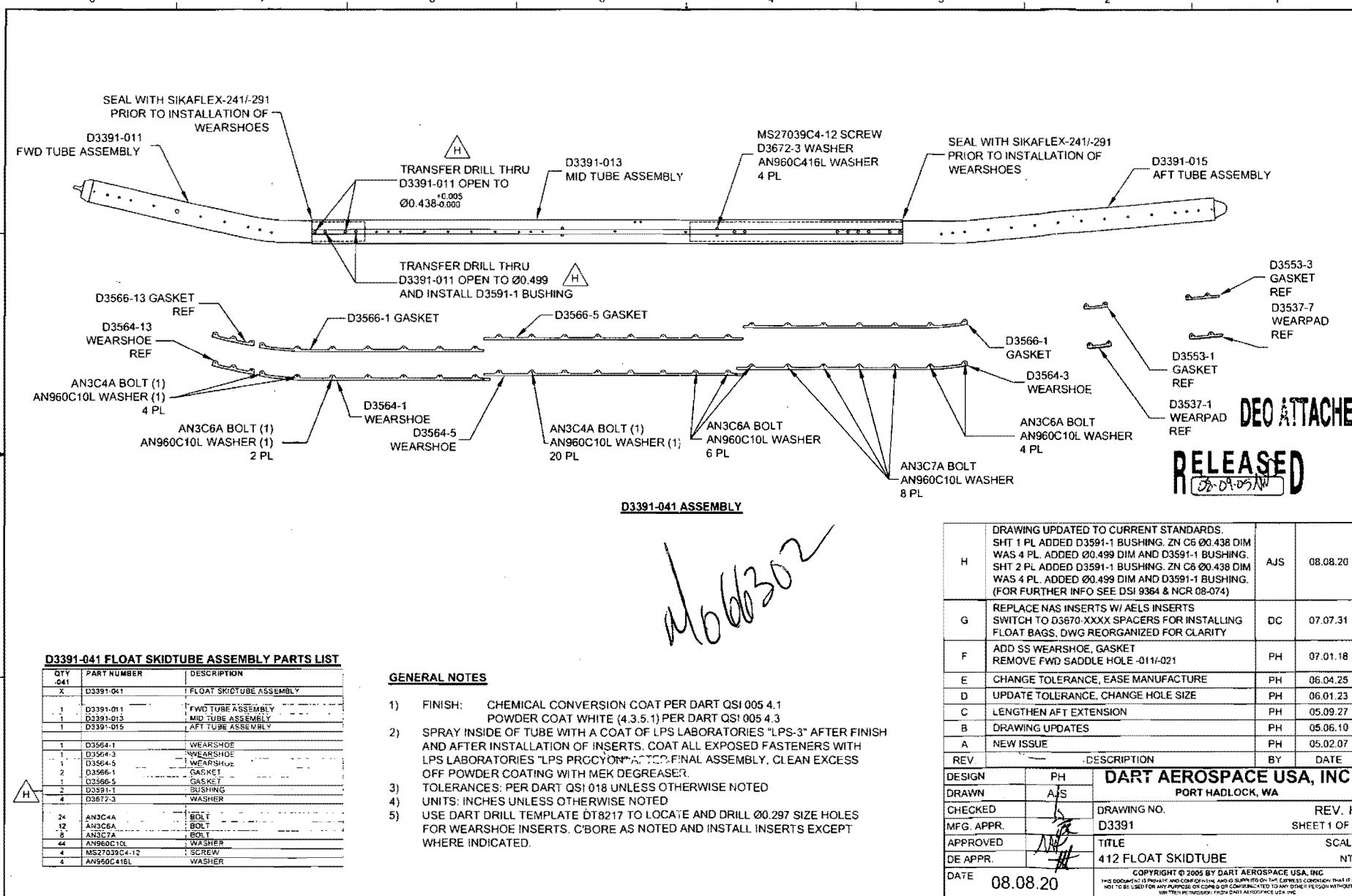
Date: 11-5-5

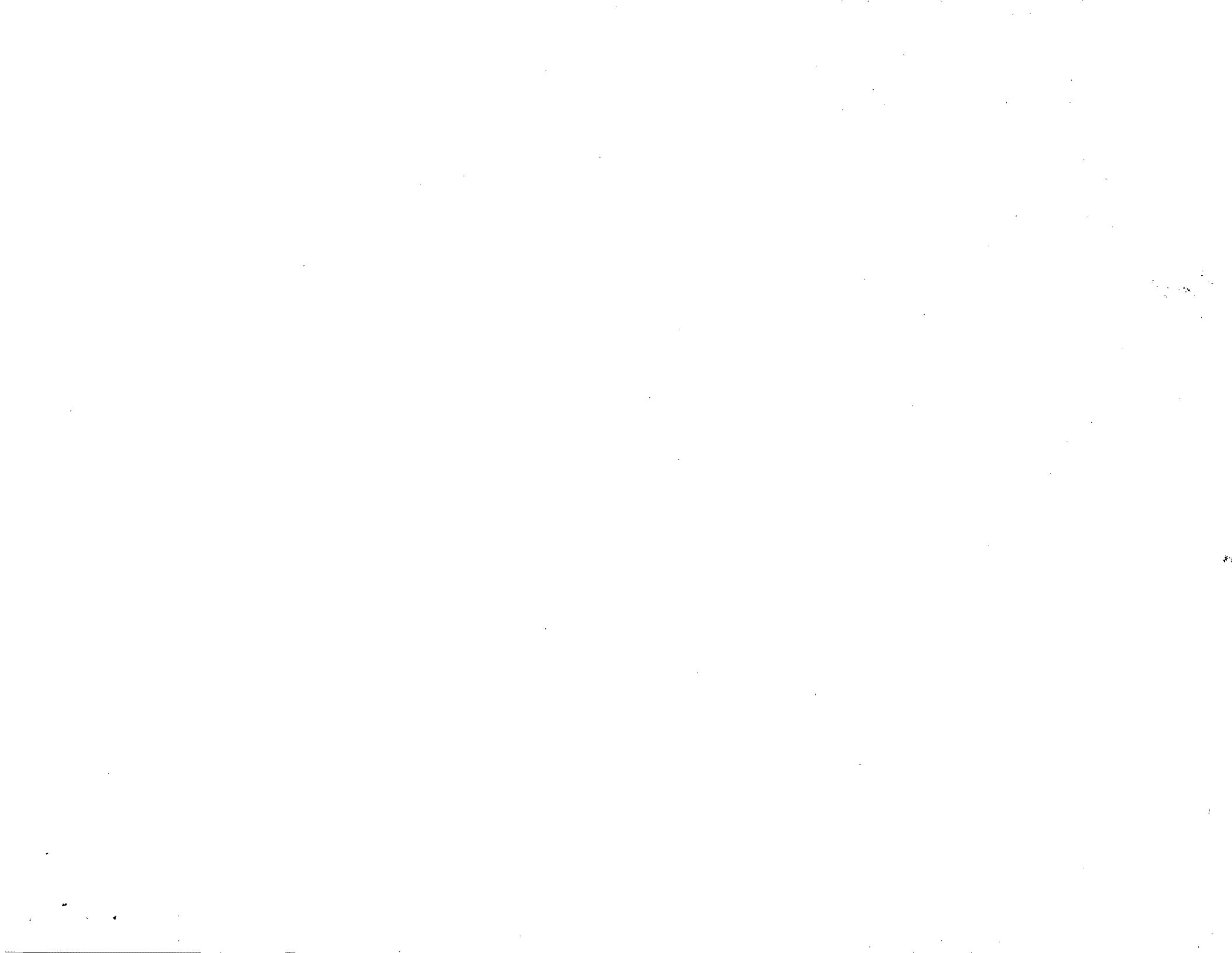
Date: 11/05/10

Date: N/A

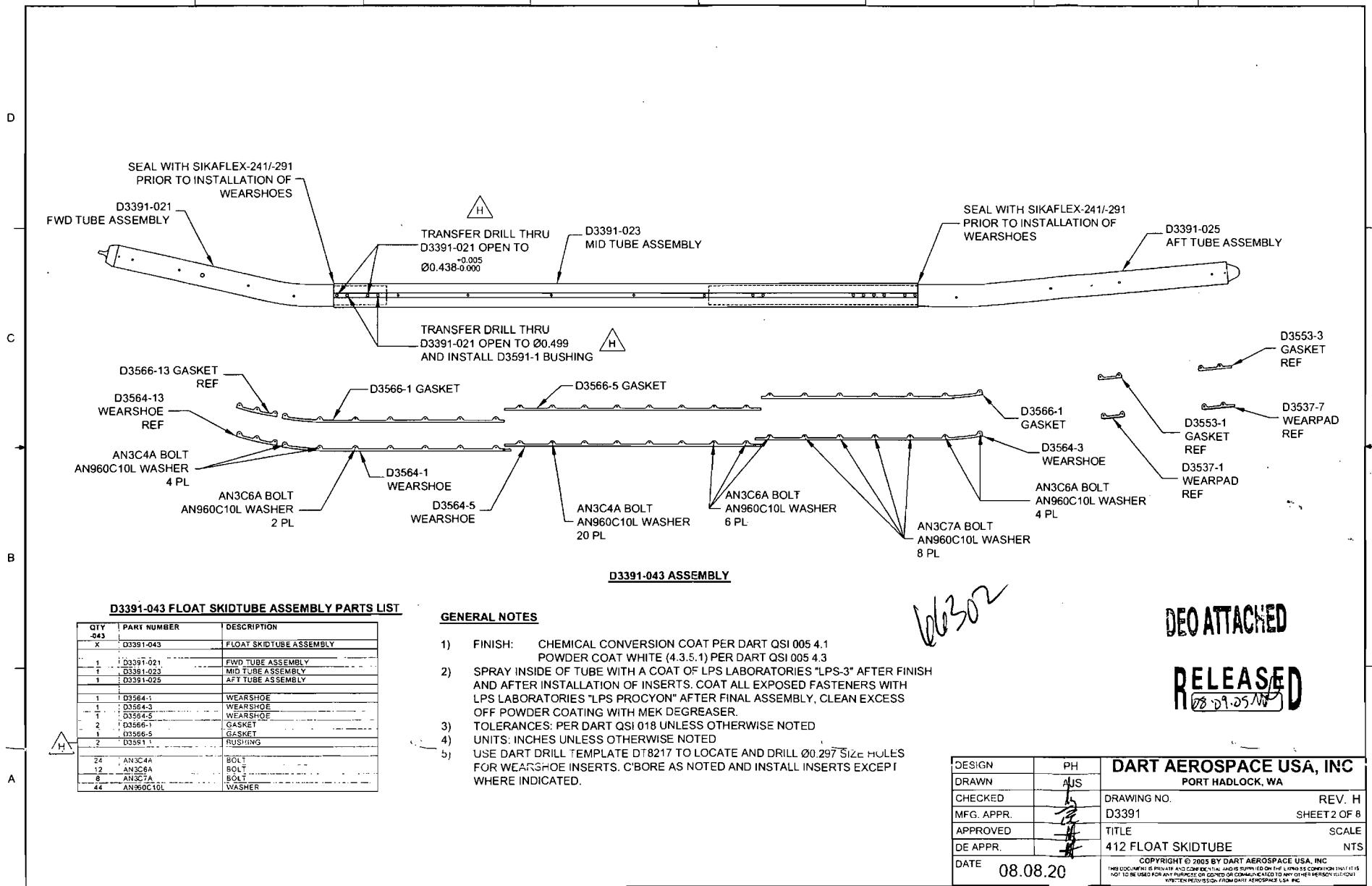
Rev	Date	Change	Revised by	Approved
A	06.04.27	New Issue P/O D3391-011/-021	KJ/JLM	
B	06.06.19	Tolerances revised per D3391 Rev. E	KJ/JLM	
C	07.03.21	Dimensions removed per Dwg rev. F	KJ/JLM	
D	07.11.23	Dwg Rev. updated	KJ/EC/DD	
E	09.12.14	Dwg Rev updated	KJ	 



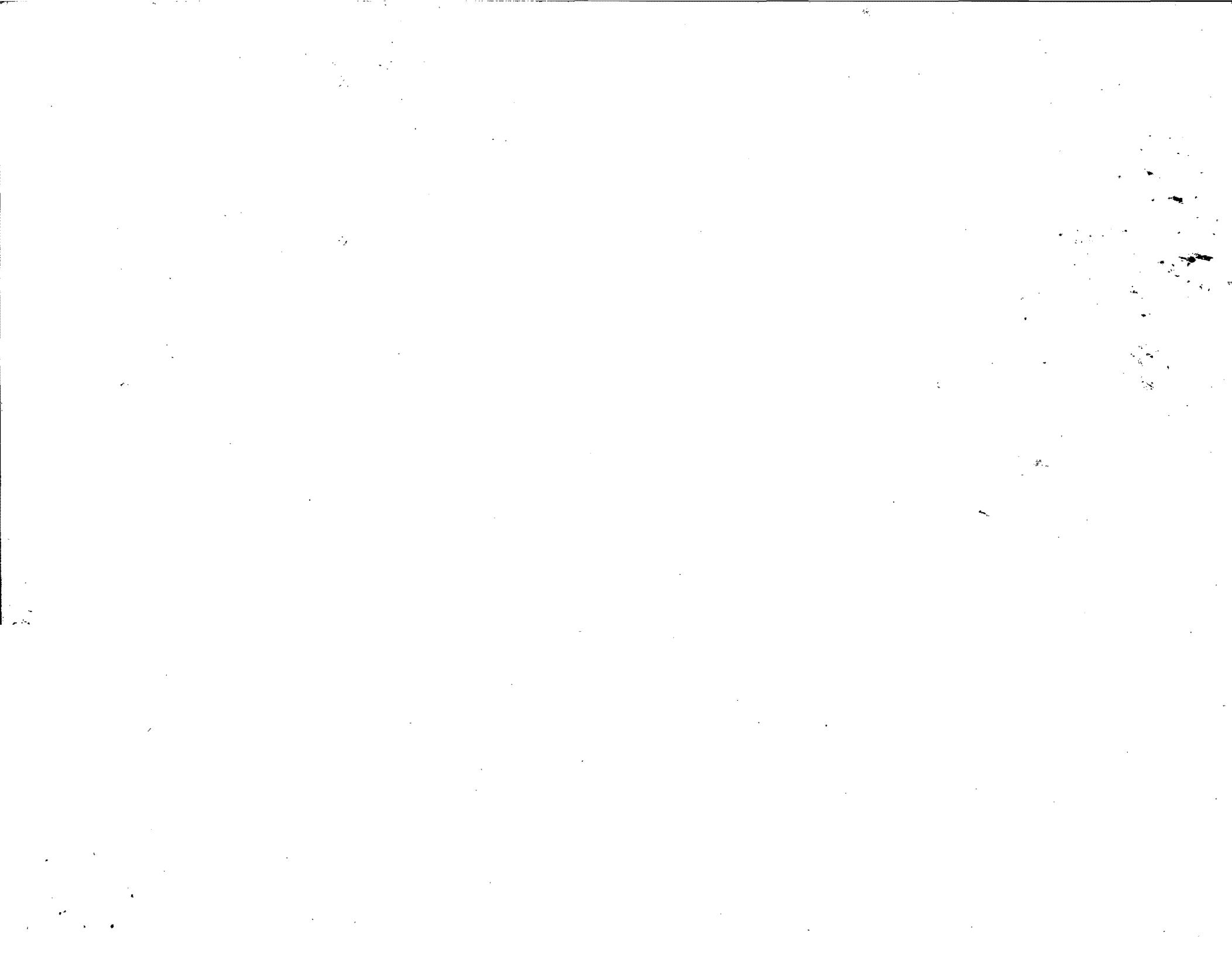


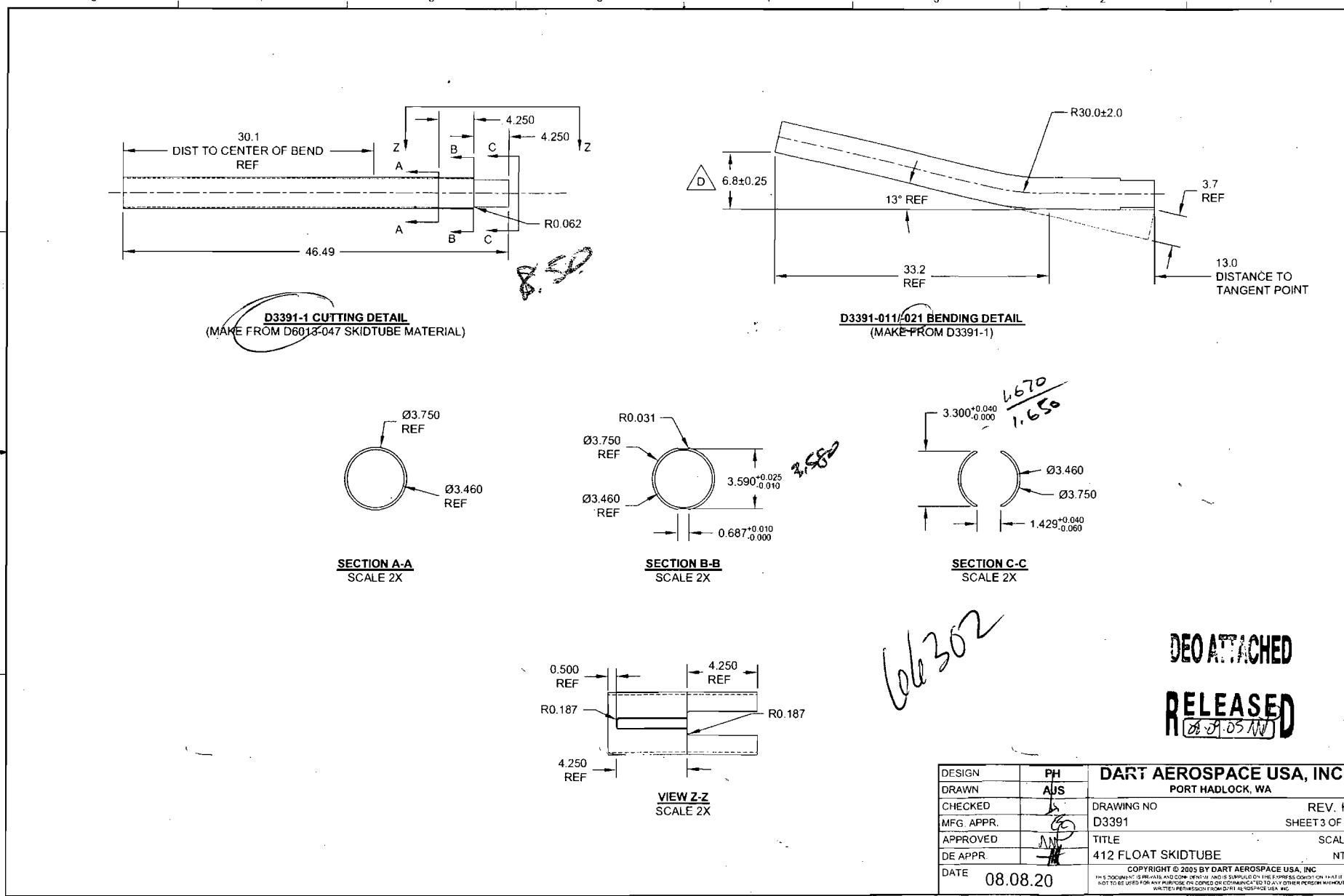


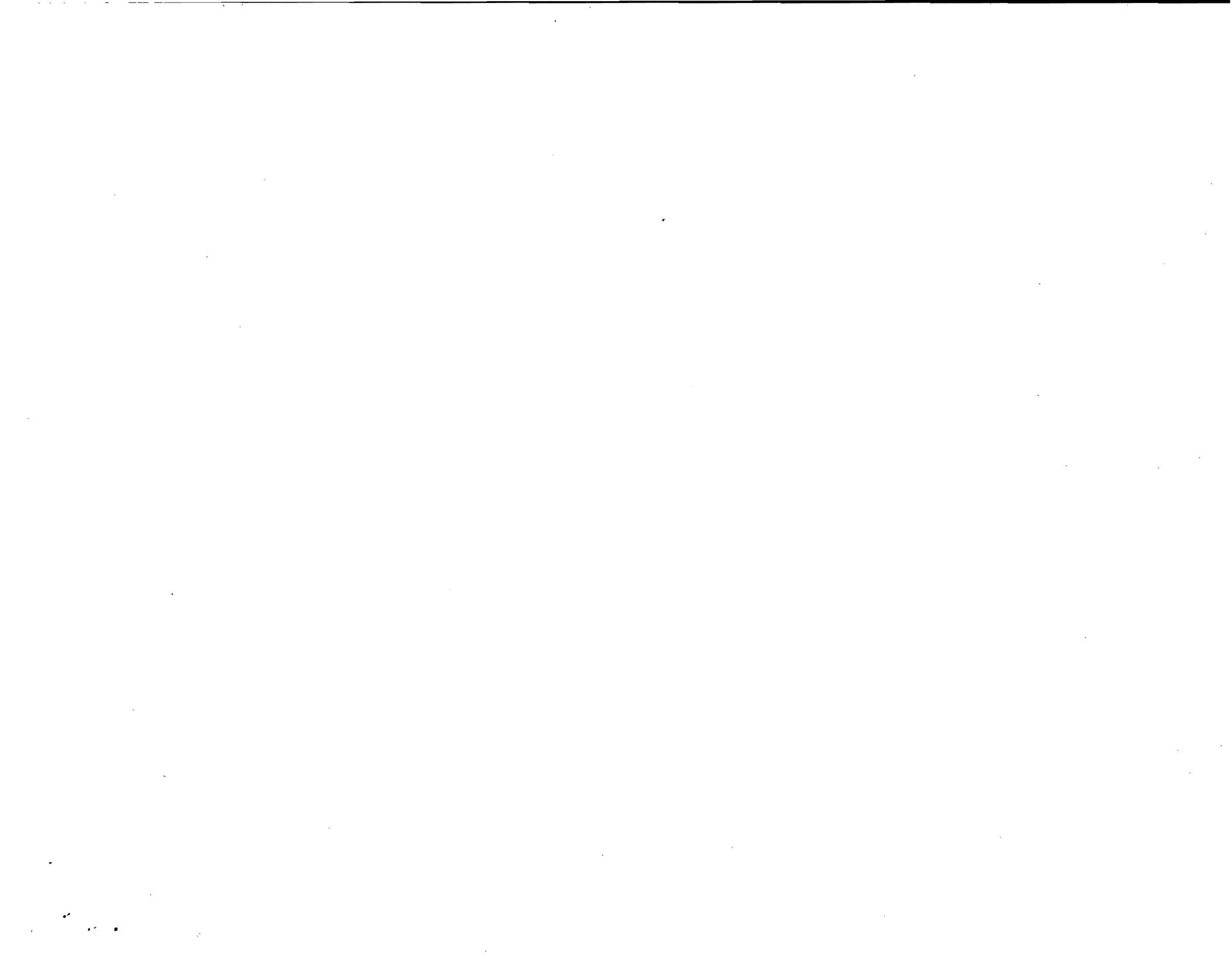
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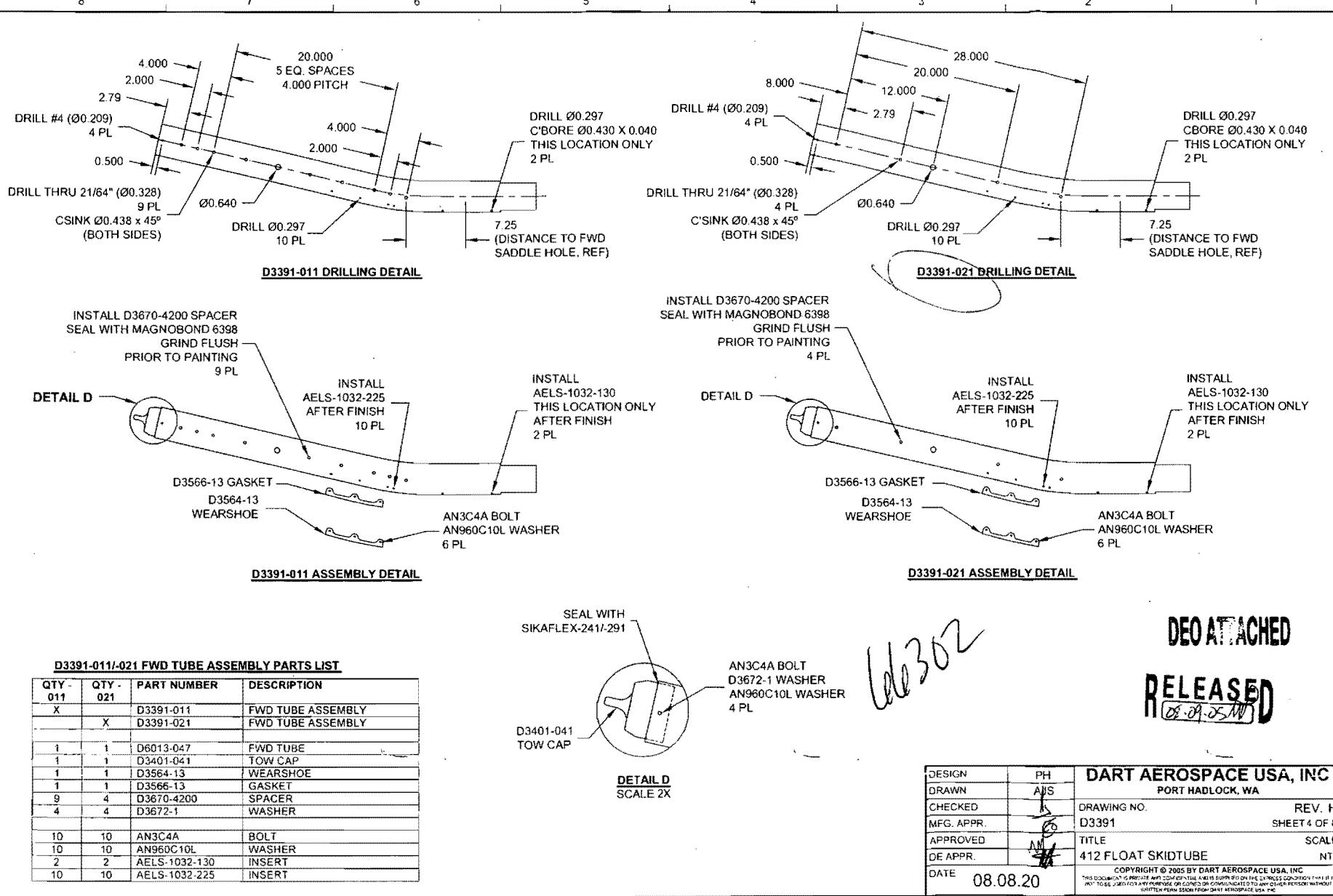


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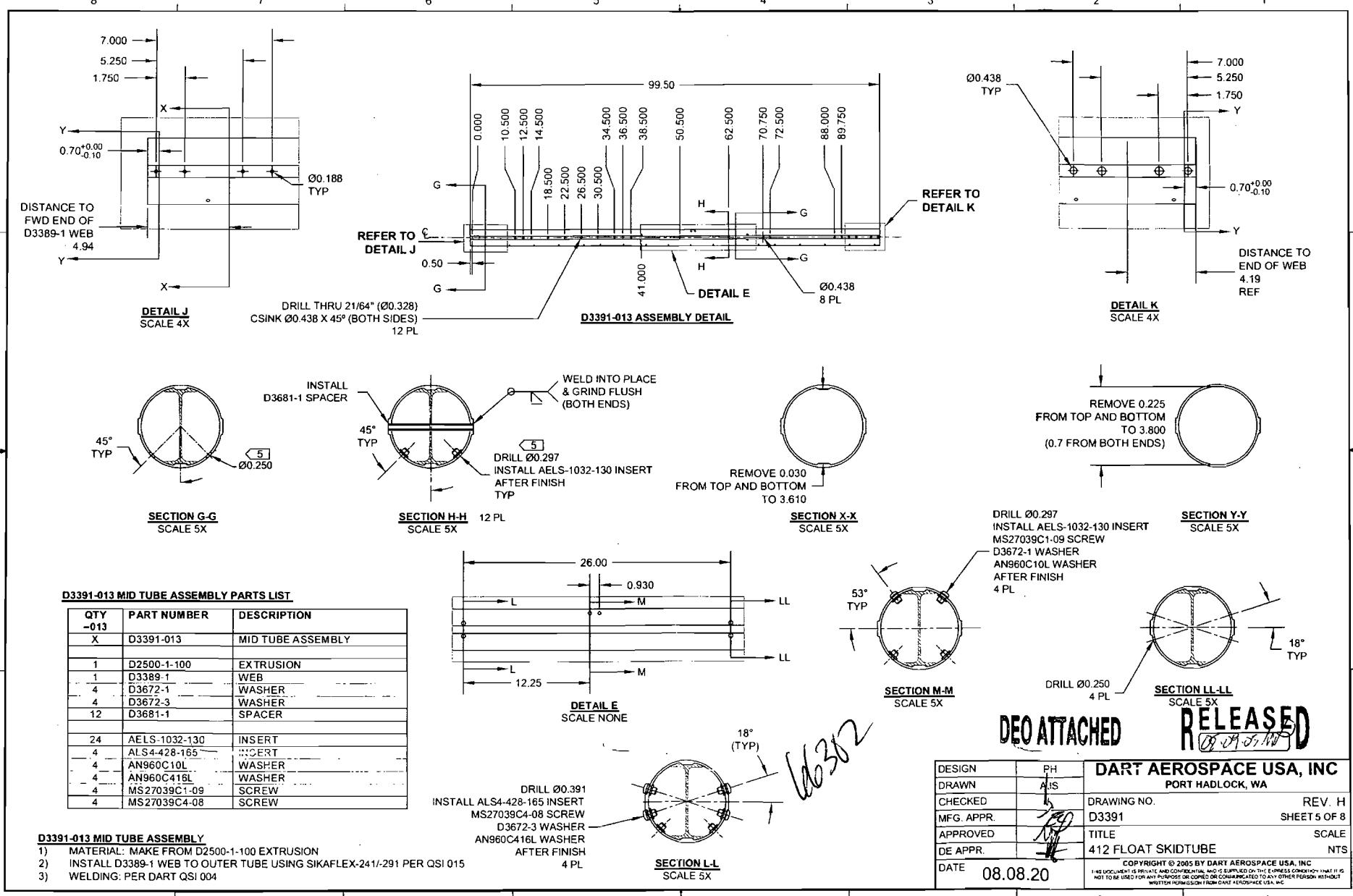




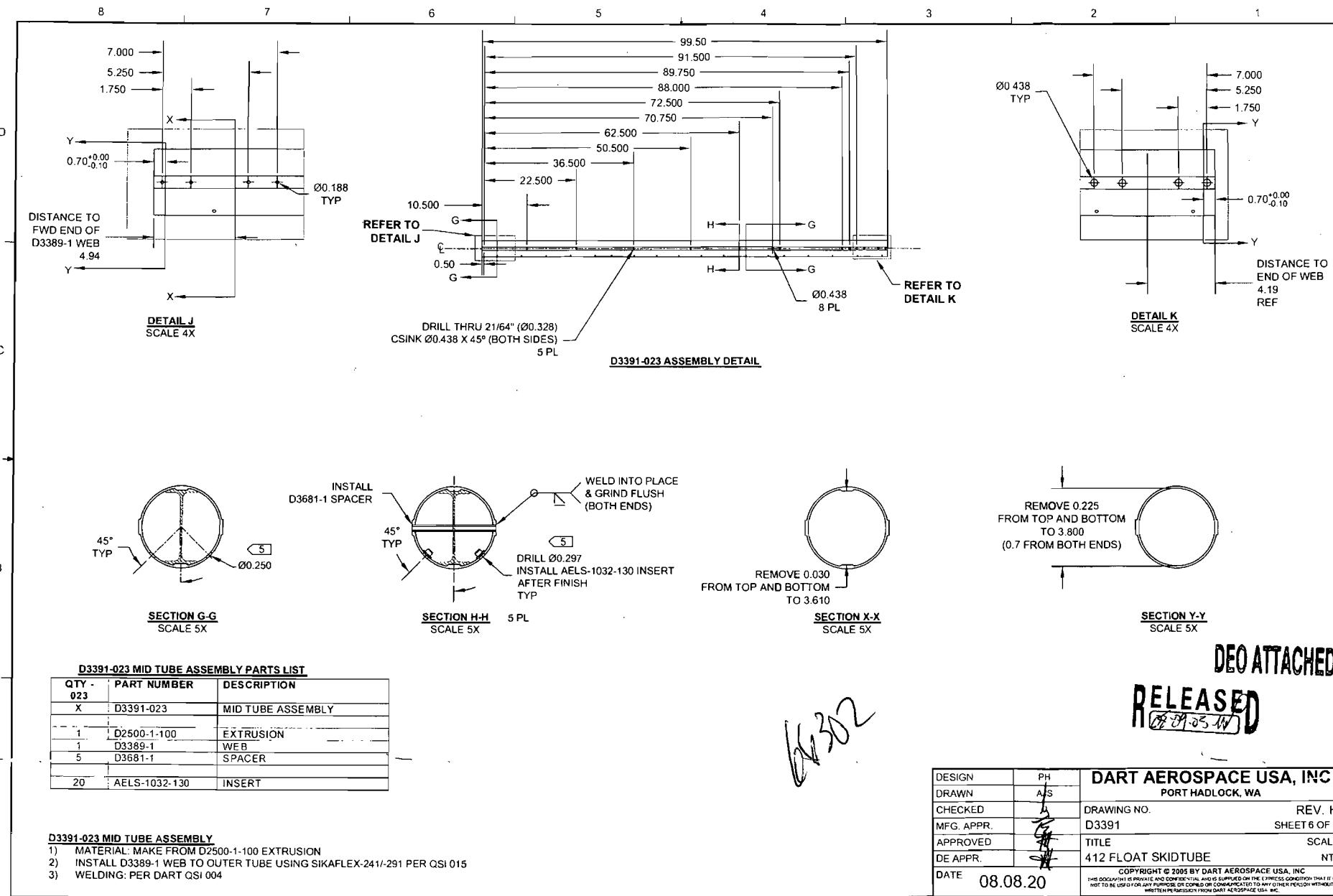




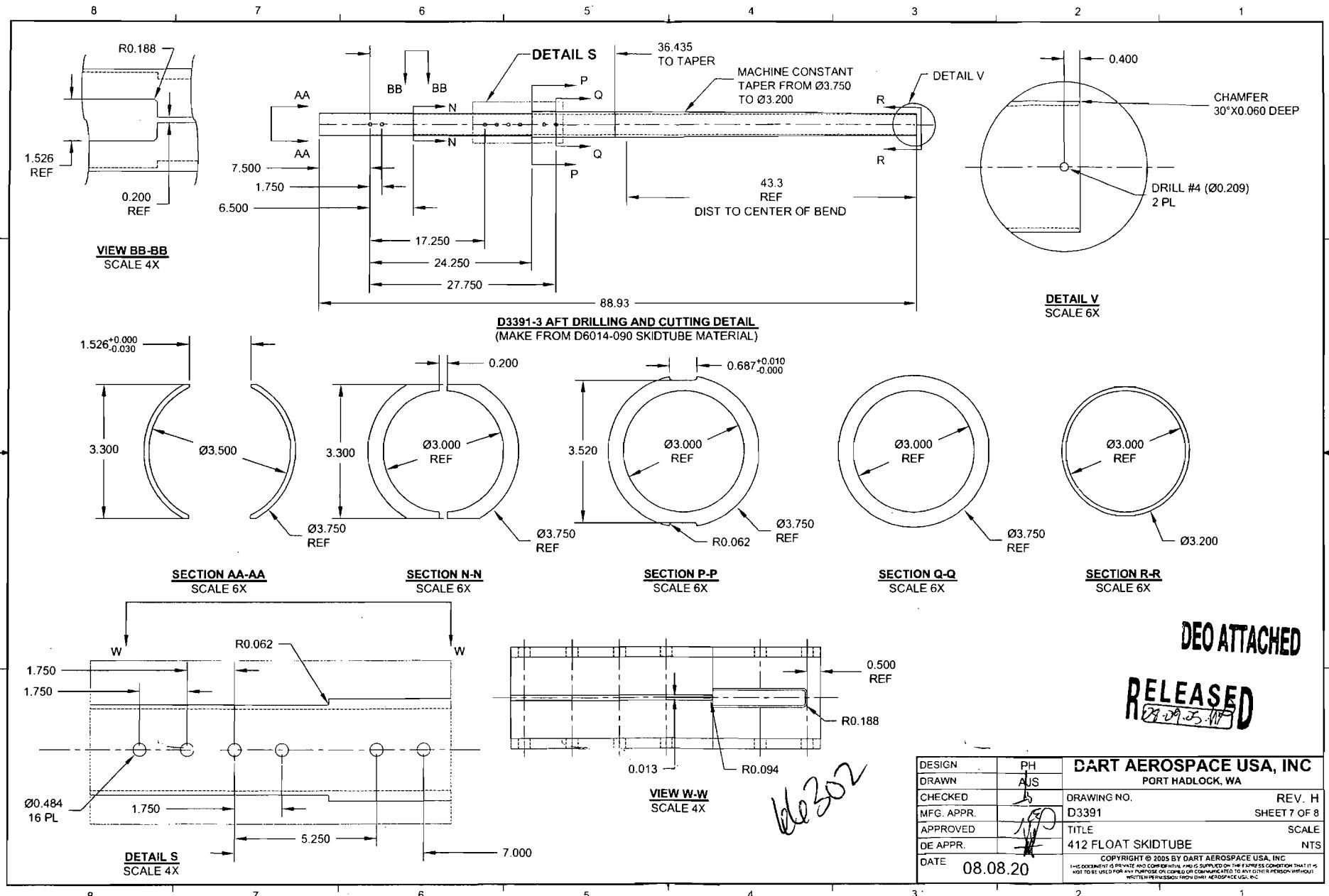
66

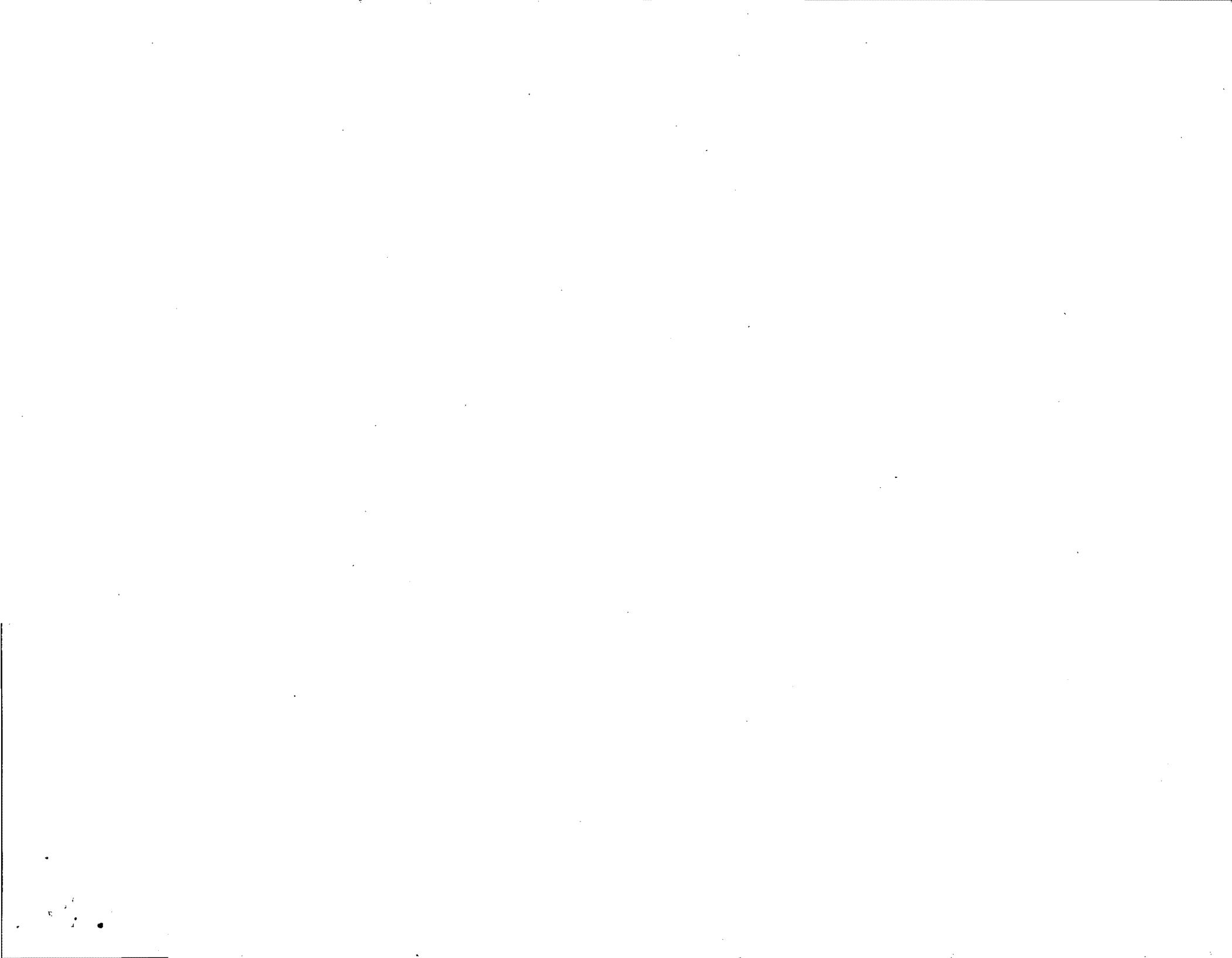


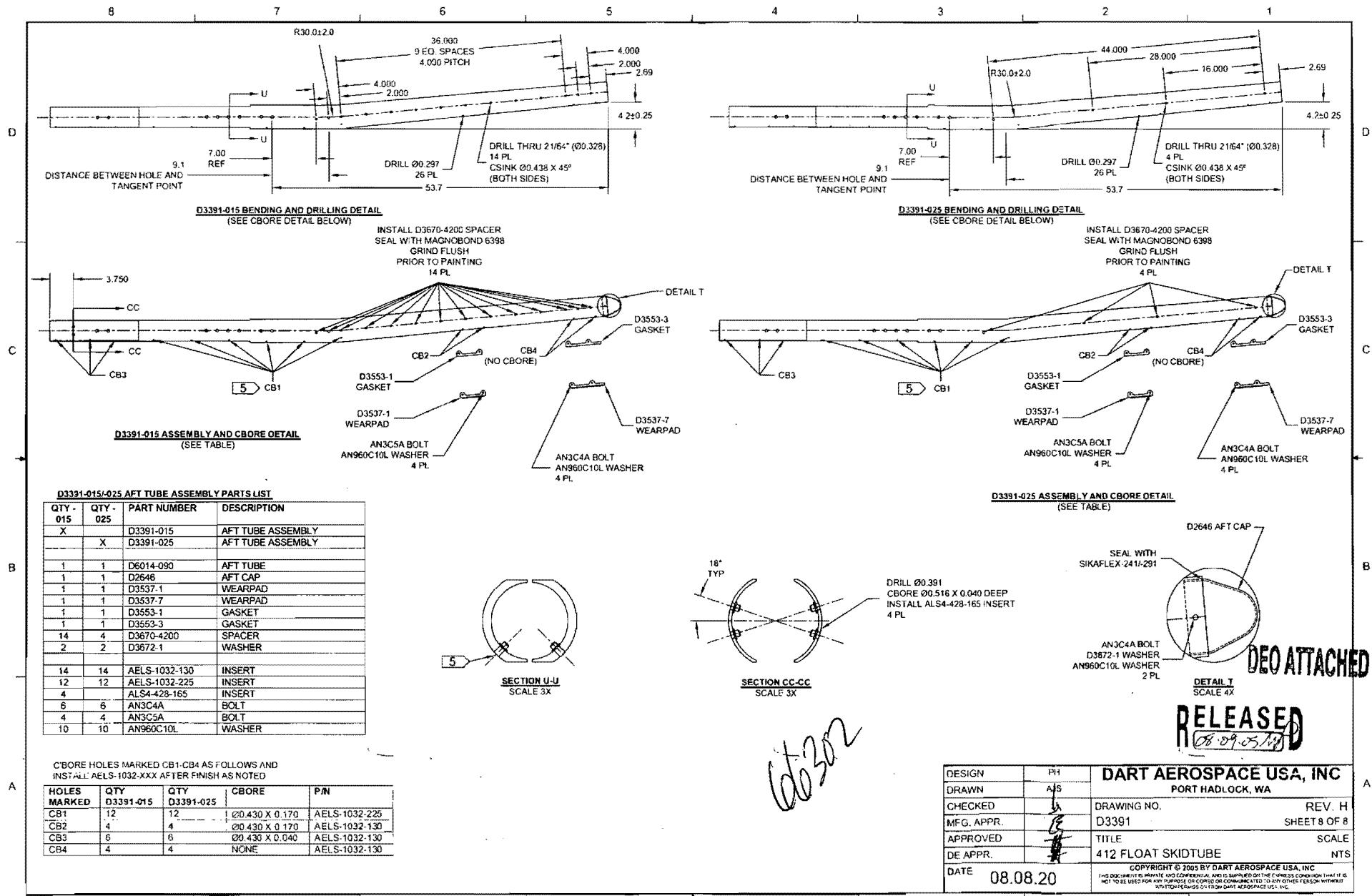












DESIGN	PH	DART AEROSPACE USA, INC		
DRAWN	AJS	PORT HADLOCK, WA		
CHECKED		DRAWING NO.	REV. H	
MFG. APPR.	E	D3391	SHEET 8 OF 8	
APPROVED		TITLE	SCALE	
DE APPR.		412 FLOAT SKIDTUBE	INTS	
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SHIPPED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN CONSENT OF DART AEROSPACE USA, INC.		



DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>(1)</i>	CHECKED <i>1</i>	MFG. APPR. <i>AA</i>	APPROVED <i>MP</i>	DE APPR. <i>MP</i>		
DATE 09/09/23	DATE 09/09/24	DATE 09/09/25	DATE 09/09/30	DATE 09/09/30	DATE 09/09/30	

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.~~ COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
2010-02-02

MP

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